

# Work Order ID 57879



Page 1

Monday, April 19, 2010 3:33:42 PM

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Item Name: Aft Door Assembly

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

Solis/19

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

CL PS 10-4-20

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57879**

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Item ID: D350-588-041

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Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity &amp; Process Sheet are attached

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.  
Audit process sheet.

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



Scolostis

QC

Memo

0.00

Quality Control

⑩

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-5-18

160

QC4- 100% Inspect kits for completeness

0.00



Scolostis

QC

Memo

0.00

Quality Control

⑩

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Item Name: Aft Door Assembly

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Identify as per dwg &amp; Stock Location: 42

0.00

Revd

Memo

0.00

10-5-20 RSP

Packaging

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/2010

Quality Control

U 100520

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 57879

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN526C832R9		Purchased	No			140	Each	418.0000	8.0000			
											BT	10-05-18
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327 418  
113845 18  
114341 200  
114405 200

AN960JD10 NAS 1149003635 Purchased No 140 Each 0.0000 2.0000



Washer

AN960JD8 NAS 11490N8323 Purchased No 140 Each 0.0000 8.0000



Washer

D2143 Manufactured No 140 Each 35.0000 1.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST198 35  
37739 9  
55323 26

BT 10-05-18

BT 10-05-18

BT 10-05-18

BT 10-05-18

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Work Order ID: 57879



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2144		Manufactured	No			140	Each	60.0000	1.0000			
											10-05-18	
Hinge Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST198 60

55061 8

55179 52

D2463

Manufactured No

140 f

512.5036 7.2500



Seal



10-05-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST404 512.5036

43841 3

50075 15.7536

55561 493.75

(D2463-0870) cut (1) at 7.25"  
\*\*\*\* per kit\*\*\*

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2585	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 107.0000	Remaining 2.0000	Qty	Date	Status
											85 10-05-18	
Mounting Channel												

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST018 62

53798 2

55313 60

x2

Main Warehouse

ST019 45

56524 45

D2586

Manufactured No

140 Each

85.0000 2.0000



Door Latch



85 10-05-18

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST204 85

55314 85

x2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2621	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 118.0000	Remaining 2.0000	Qty	Date	Status
Latch Plate, 350 Spacepod											ET 10-05-18	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

118

46842

49

56526

69

x2

D2857-1

Manufactured No

140

Each

38.0000

1.0000



Hinge Bracket



ET 10-05-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST026

38

55019

19

56529

19

x1

D2857-2

Manufactured No

140

Each

48.0000

1.0000



Hinge Bracket



ET 10-05-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

48

55020

28

56530

20

x1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 57879



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			140	Each	667.0000	8.0000			
Nut											21 05-18	

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST300	400	
114330	400	
Main Warehouse		
ST301	267	
114056	67	
114227	200	

MS21042L3	Purchased	No	140	Each	1,131.000	2.0000
Nut						

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST300	1131	
113537	147	
113644	984	

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Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-15		Purchased	No			140	Each	137.0000	2.0000			
Screw												

ST 10-05-19

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST292

137

112794

37

114056

100

AN526C1032R7

Purchased

No

155

Each

136.0000

2.0000



Screw

10-5-19 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST328

136

113064

66

113749

20

114056

50

AN526C832R8

Purchased

No

155

Each

140.0000

8.0000



Screw

10-5-19 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327

140

113595

140

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10	NAS1149003632	Purchased	No			155	Each	0.0000	2.0000			
Washer												
AN960JD8	NAS1149008321	Purchased	No			155	Each	0.0000	16.0000			
Washer												
D2150		Manufactured	No			155	Each	70.0000	2.0000			
Packer Doubler, Hinge												

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST007

70

55016

16

55178

54

D2151

Manufactured No

155

Each

55.0000

2.0000

Packer Doubler, Hinge

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST007

55

51407

17

55319

38

10-5-A M114292 sl  
2 14  
10-5-A M114108 M114348  
10-5-19 sl  
10-5-19 sl

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**Dart Aerospace Ltd**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2153		Manufactured	No			155	Each	36.0000	1.0000			
											10-5-19 sl	
Door Prop												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST272

36

48373

1

55324

35

D2154

Manufactured

No

155

Each

28.0000

1.0000



Stud Bracket



10-5-19 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST007

28

44890

8

55325

20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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per DSI9414 DD verified by:EC  
10.03.29 verified by:EC


IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2237	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 155	Unit of Each	Qty on 95.0000	Remaining 2.0000	Qty	Date	Status
											10-5-19	SP
Striker Plate												

## Warehouse Loc Qty Loc Code

### Location

Main Warehouse

ST009

40

57255

40

Main Warehouse

ST010

55

55006

6

55312

49

D2461

Manufactured No

155

f

393.5000

7.2500

Neoprene "D" Seal

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST402

393.5

39782

6.5

55054

387

(D2461-0870) cut (Y) at 7.25"

\*\*\*\* per kit\*\*\*\*

D2589

Manufactured No

155

Each

0.0000

2.0000

Keys, Key Chain, 350 Hinge

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W/O: 57879		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. change					
10/5/19	155	wrong dim for cut seal length. Should be 87" not 7.25"	HA	10.05.21			S 12/05/19

Part No: D350-588-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:42 PM

Work Order ID: 57879



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2690-17		Manufactured	No			155	Each	8.0000	1.0000			
Cable												



B57534

10-5-19

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

8

56567

8

D2858-1

Manufactured No

155

Each

40.0000

1.0000



Hinge Bracket



10-5-19

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

40

45798

7

55062

12

56423

21

D2858-2

Manufactured No

155

Each

32.0000

1.0000



Hinge Bracket



10-5-19

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

32

55063

11

56048

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:42 PM

Work Order ID: 57879

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
EG-778150-550-ROL		Purchased	No			155	sf	2,302.000	1.0000			
7781 9oz Glass 50"x125yd												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST404	2302	
108932	108	
111166	419	
113905	1775	

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

6,848.000

12.0000

RIVET

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST316	6848	
104374	2848	
110398	4000	

MS20470AD4-5

Purchased

No

155

Each

618.0000

18.0000

Rivet, Universal Head

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST319	618	
111916	618	

Monday, April 19, 2010 3:33:42 PM

Shop Packet Print

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:42 PM

Page 12

Work Order ID: 57879



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			155	Each	667.0000	10.0000			
											10-5-79 SP	

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 400

114330 400

Main Warehouse

ST301 267

114056 67

114227 200

MS21042L3

Purchased

No

155

Each

1,131.000

4.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 1131

113537 147

113644 984

Monday, April 19, 2010 3:33:42 PM

Shop Packet Print

Page 12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, April 19, 2010 3:33:42 PM

Page 13

Work Order ID: 57879



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-08-11		Purchased	No			155	Each	119.0000	2.0000			



Screw



16-5-1958

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST288

50

114382

50

Main Warehouse

ST290

69

111977

19

113749

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

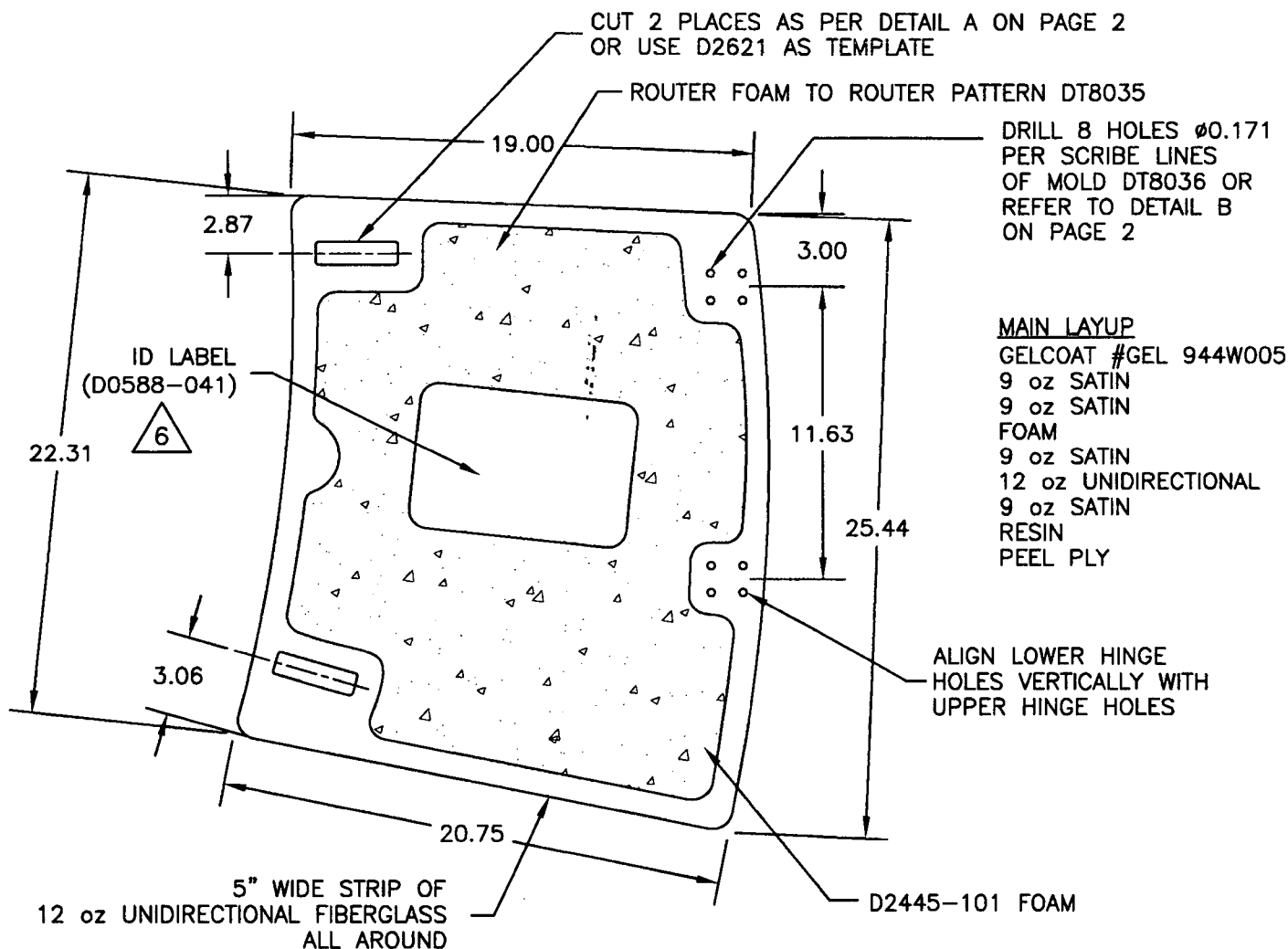
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

CL1014/20

W10: 57879

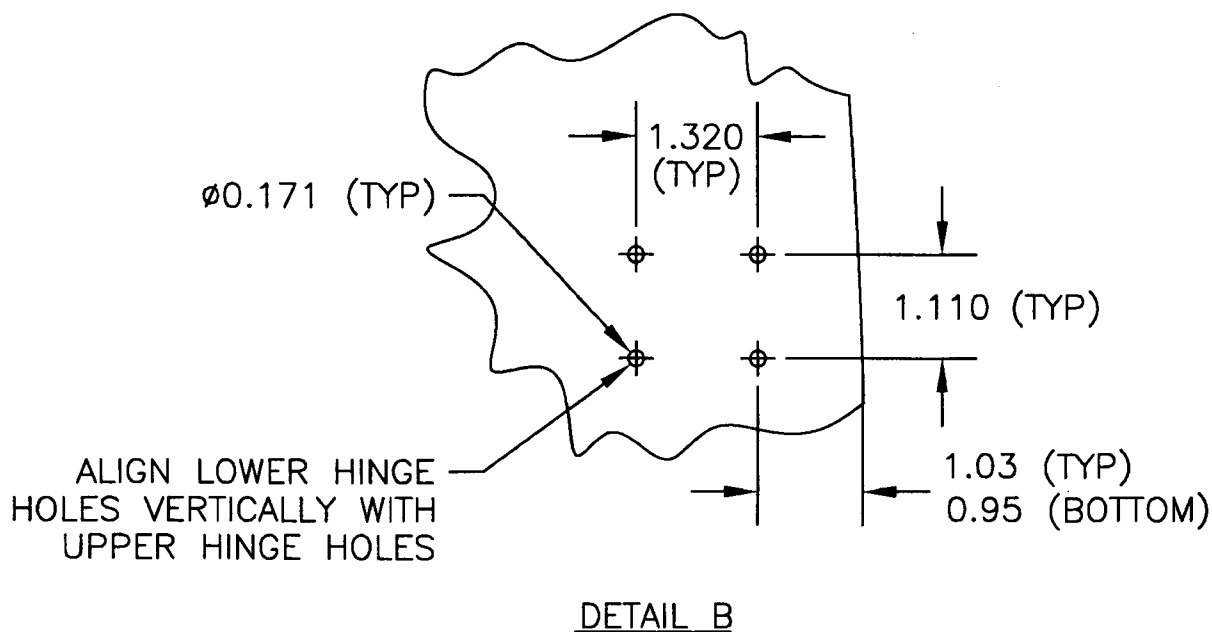
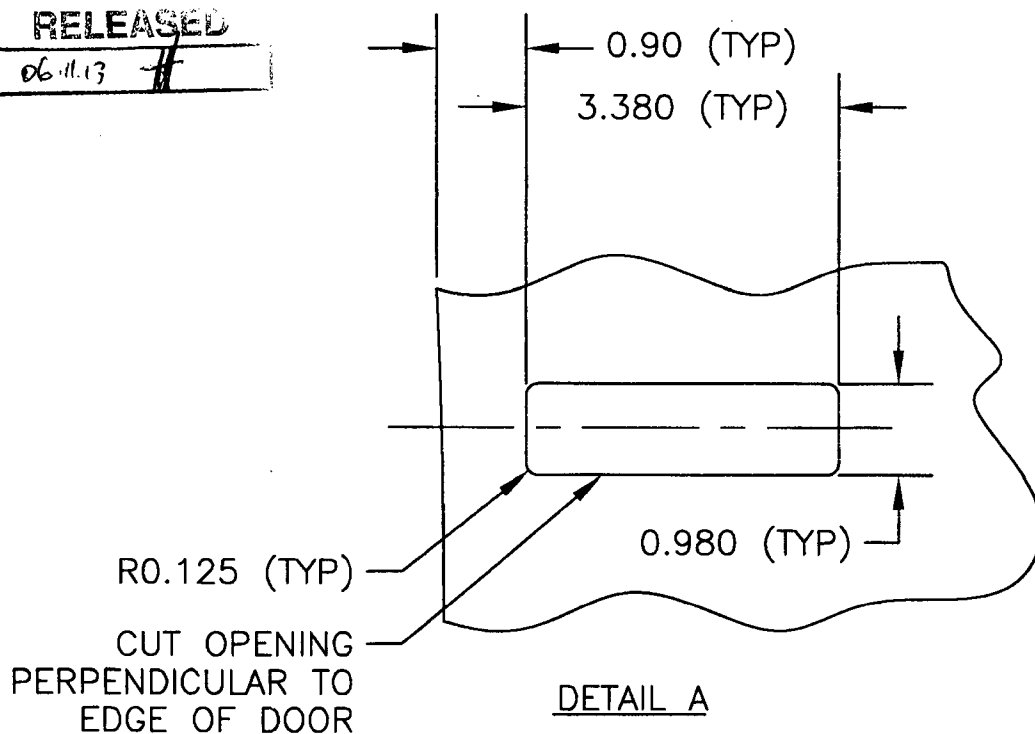
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DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED  
06.11.13 *[Signature]*



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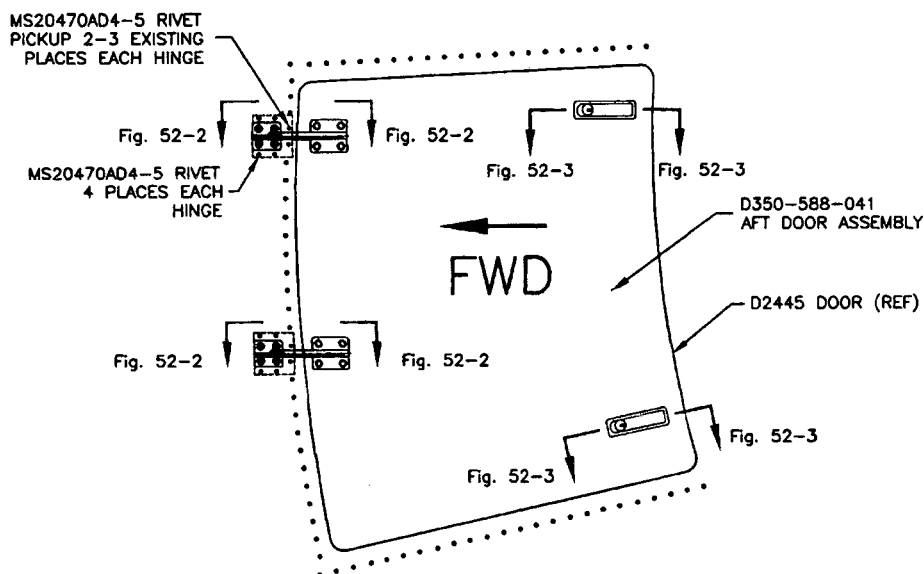


Figure 52-1: Baggage Door Outside View

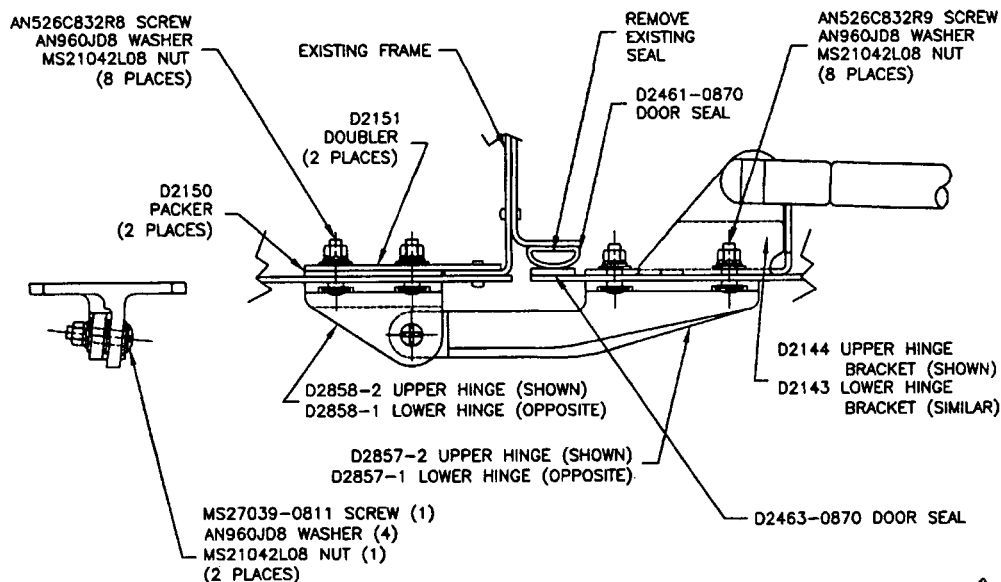


Figure 52-2: Hinge Detail

C/L 10/4/20  
W10:57879

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52-00-00

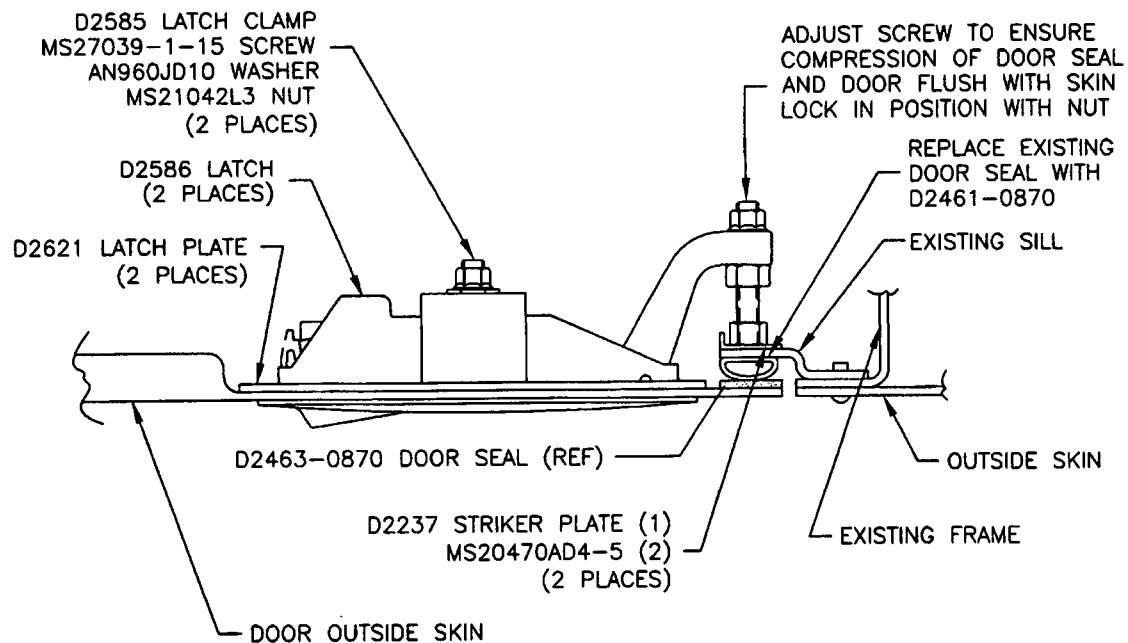


Figure 52-3: Latch Section

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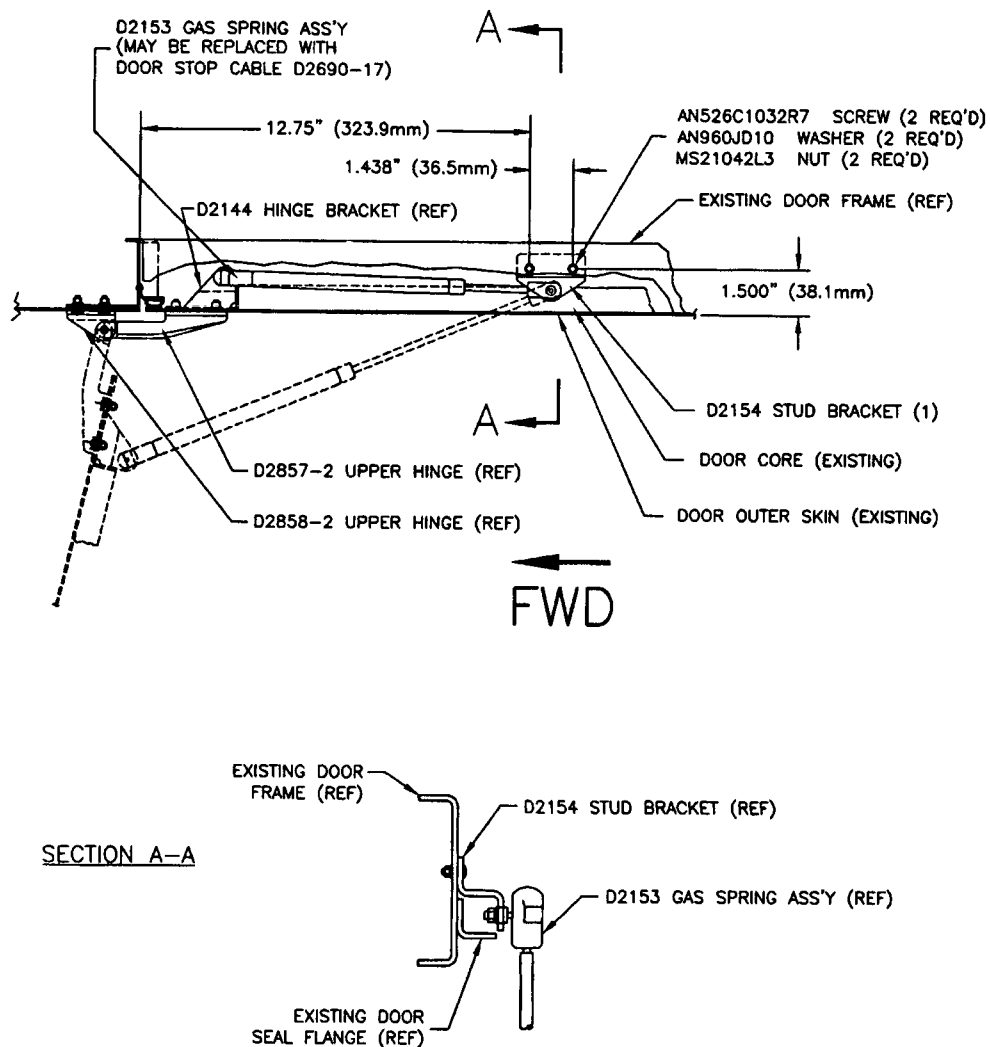
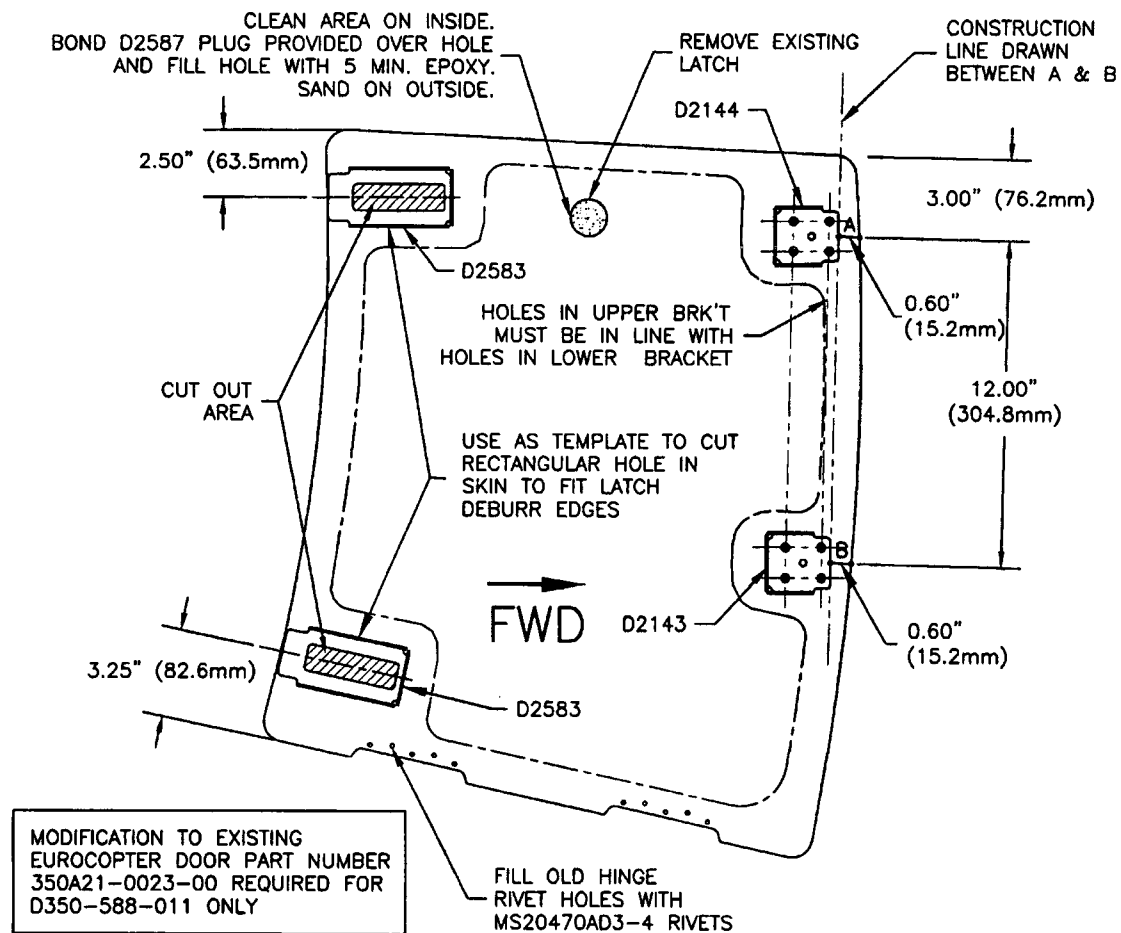


Figure 52-4: Gas Spring Installation

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52-00-00

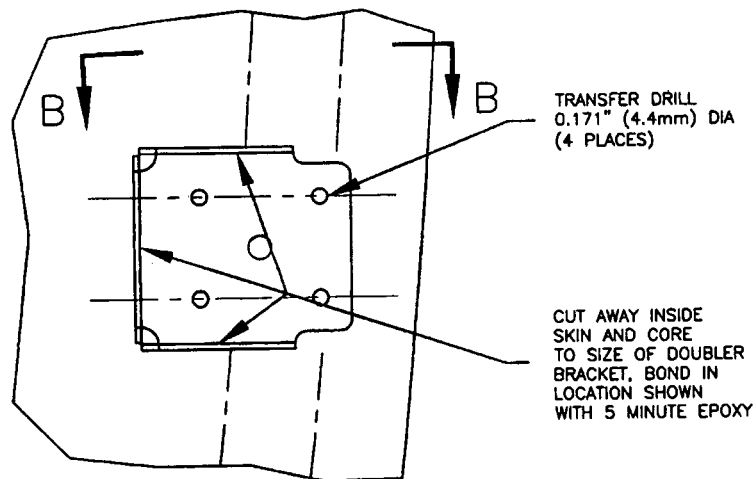
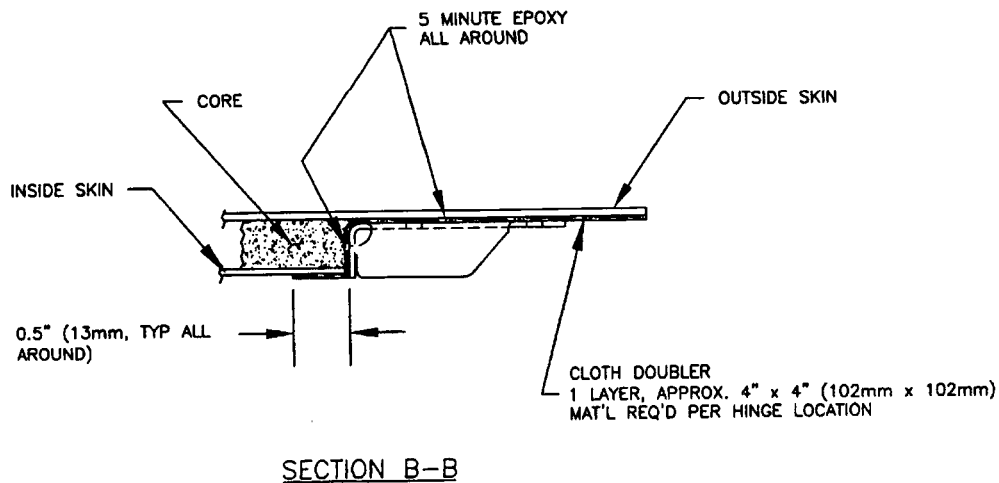


**Figure 52-5: Baggage Door Inside View**

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**52-00-00**





**Figure 52-6: Typical Doubler Bracket Installation**

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DART AEROSPACE LTD.

ICA-D350-588

ICA Page 33 (34 blank) of 34

### 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-011 Aft Door Assembly weight in excess of standard Eurocopter Door.

### 52.4 PARTS LISTS

588	588	Part Number	Description
041	011		
8	8	D350-588-041	AFT DOOR ASSEMBLY
	8	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
	1	<del>D2143</del>	HINGE DOUBLER
	1	<del>D2144</del>	HINGE DOUBLER
2	2	D2150	HINGE PACKER
	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
	1	D2461-0870	NEOPRENE D SEAL
	1	<del>D2463-0870</del>	1/2" FOAM SEAL
	1	D2583	LATCH BRACKET
2	2	<del>D2585</del>	LATCH CLAMP
2	2	<del>D2586</del>	LATCH
	1	D2587	PLUG
	1	D2589	KEYS, KEY CHAIN
	1	<del>D2621</del>	LATCH PLATE
	1	D2690-17	CABLE, DOOR STOP
	1	<del>D2857-1</del>	LOWER HINGE BRACKET
	1	<del>D2857-2</del>	UPPER HINGE BRACKET
	1	D2858-1	LOWER HINGE BRACKET
	1	D2858-2	UPPER HINGE BRACKET
6	6	AN526C832R8 /	SCREW (or AN526-832R8)
	2	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
4	4	AN960JD8	WASHER -8
	4	AN960JD10	WASHER -2
	12	MS20426AD3-4	RIVET
13	13	MS20470AD4-5	RIVET
13	13	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	<del>MS27039-1-15</del>	SCREW
2	2	MS27039-0811	SCREW
	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33033
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
14/05/2010	20/04/2010	13866	Brigitte Golden	11710			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line #1 D350-588-041 Aft Baggage Door (D2445) B57879 U de M : Each Drawing N° : D2445 Rév. : D			
				<u>No. lot</u> 43645		<u>Qté</u> 1	
				Scelos/LS			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2009-02-09 08:10:49  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.

Numéro Job : 43645

Numéro Soumission : 2017

Numéro B.A. :

Cette fois : 2009-02-09 No. B.V. :

Prsht Rev. : NC

Prem. fois : - -

Job précédente : 43644

Type :



Écrit par :

Vérifié &amp; Approuvé par :

Commentaires :

N° de pièce Dart Aerospace: D2445

N° Delastek Composites: DKC134-0013

N° de projet Delastek: DK-362

 Process Sheet Rév.: 10 Modification du planning afin d'y inclure le  
 N° I.G 0008 ( Primer )

Nom Dessin : AFT BAGGAGE DOOR D2445

 Numéro Article : ~~DKC134-0013~~

Numéro Dessin : D2445

Projet Numéro : DKC134

Révision dessin : D

Matériel : Fibre 7781 et Résine 411-350

Date Dûe : 2009-02-16

Qté:

1 Udm: UNITE

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)  
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MATÉRIEL DART

 Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon  
 le QSI-006.

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AAC0273 Gel Coat Blanc N° Gel 944W005

 Commentair Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s)  
 Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-27127-2

4.0 AAC0275 Catalyst N° DDM-9

 Commentair Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s)  
 Catalyst N° DDM-9

N° de Lot: 1-22176-1

Date: Lundi, 2009-02-09 08:10:49  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43645

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

5.0	AC0260	Acetone
-----	--------	---------

Commentair Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)  
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 26-4-10 Sceau:  Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

7.0	GEL COAT.	APPLICATION DE GEL COAT
-----	-----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. ( Visuel du Gel Coat )

Date: 26-4-10 Sceau:  Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

8.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)  
Tissu à délaminer Release ply B

9.0	AC0407	Wrightlon 5200 Bleu P3
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Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)  
Wrightlon 5200 Bleu P3

10.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)  
Feutre de drainage N° Airweave N 10

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43645

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

11.0

AC0752

Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)  
Stretchlon 200 poche à vide Vert

12.0

AAC0326

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)  
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot:

1-26697-1

13.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s)  
Fiberglass 12 oz Unidirectional

N° de Lot:

1-22549-1

14.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

15.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 26-4-10

Heure Début:       

Heure Fin:       

Sceau:       



16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)  
Catalyst N° DDM-9

N° de Lot:

~~1-22176-1~~ 1-22176-1

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 43645

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-27127-1

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date 26-4-10 Heure Début: — Heure Fin: — Sceau:

19.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date 26-4-10 Heure Début: — Heure Fin: — Sceau:

20.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date 26-4-10 Heure Début: — Heure Fin: — Sceau:

Curing début: 12:35 Curing Fin: 8:00



Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43645Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
21.0	AAC0275	Catalyst N° DDM-9

Commentaire Qty.: 0.0042 PINTE(s)/Unit Total : 0.0042 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-22176-1

22.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentaire Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26380-1

23.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 22/01/14 Heure Début: 4:05 Heure Fin: 4:10 Sceau:



24.0	AAC0452	Polybond B46F
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Commentaire Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)  
Polybond B46F

N° de Lot: 1-7089-1

25.0	DKC134-0029	Foam Core N° D2445-101 ( Pour AFT Baggage Door )
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Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D2445-101 ( Pour AFT Baggage Door )

#JOB: 43653

26.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 21-04-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:



Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43645

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

27.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE





Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 27-04-10 Heure Début:        Heure Fin:        Sceau:  

Curing Début: 9:20 Curing Fin: 10:40

28.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-22176-1

29.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-27342-1

30.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 30/04/10 Heure Début:        Heure Fin:        Sceau: 

31.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43645

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 30/04/10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 30/04/10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: 10:30 Curing Fin: 8:00

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 3-5-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 3-5-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

